

Work Order ID 164288

Monday, July 17, 2017 9:20:40 AM

164288

Page 1

Item ID: D4634-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fwd, Center Ceiling Panel
Start Date: 7/21/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 8/4/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: DAS 21 9-09 Date: JUL 17 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4634	G								
110	Purchasing	0.00							DAS 13 9-09
110	Purchasing								
Purchasing	Memo	0.00							
Purchasing	ISSUE P/O: <u>37108</u>								
	SUPPLIER: PLASTECH								
	MANUFACTURE D3947-1 AS PER DWG								
	NOTE: TRIM TO FINISHED DIMENSIONS								
	C OF C IS REQUIRED								
140	Receive & Inspect for Damage & Mat'l Certs receiving	0.00							
140	Packaging								
Packaging	Memo	0.00							

4x SPT 8-30

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

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Page 2

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Item Name: Fwd, Center Ceiling Panel
Start Date: 7/21/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 8/4/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC6- All purchased or subcontracted products	0.00							
150									
QC	Memo	0.00				⑦	17-09-12	10	
Quality Control									
170	Identify as per dwg & Stock Location: <u>F6242</u>	0.00							
170									
Packaging	Memo	0.00				①			Dr. 17/09/12 DAS 07 9-89
Packaging						③			17/09/12
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							17/9/18
Quality Control									

SEP 13 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

Monday, July 17, 2017 9:20:43 AM

Page 1

Work Order ID: 164288

164288

Parent Item: D4634-1

D4634-1

Parent Item Name: Fwd, Center Ceiling Panel

Start Date: 7/21/2017

Required Date: 8/4/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev. A 12/08/09 New Issue DL
12/11/08 Document release DL VERIFIED BY:JLM IPP Rev B
Dwg Update DL verf: DD IPP Rev C 13/07/09
DL IPP Rev D Dwg Update 13/12/23
DL IPP REV E Dwg update 14/01/09
DL IPP Rev F Dwg. update 14/02/03
DL IPP Rev G Dwg. Update 15/01/27
DL IPP Rev.H 17.06.13 Now outside process DP
Verify DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4634-1P		Purchased		No		110	Each	0.0000	1	4			
D4634-1P									**				
Fwd, Center Ceiling Panel													
MLEXS.093-F6006-07		Purchased		No		110	sf	1,063.960	17.3	69.2			
MI FXS 093-F6006-07									**				
GE PLASTICS LEXAN SHEET (LIGHT GREY)													

4x8078-30.

SEP 13 2017

Location

Loc Qty

Loc Code

MAT023

69.56

m129738

69.56

RM

994.4

m135322

194.4

m135517

800

DQA: _____ Date: _____

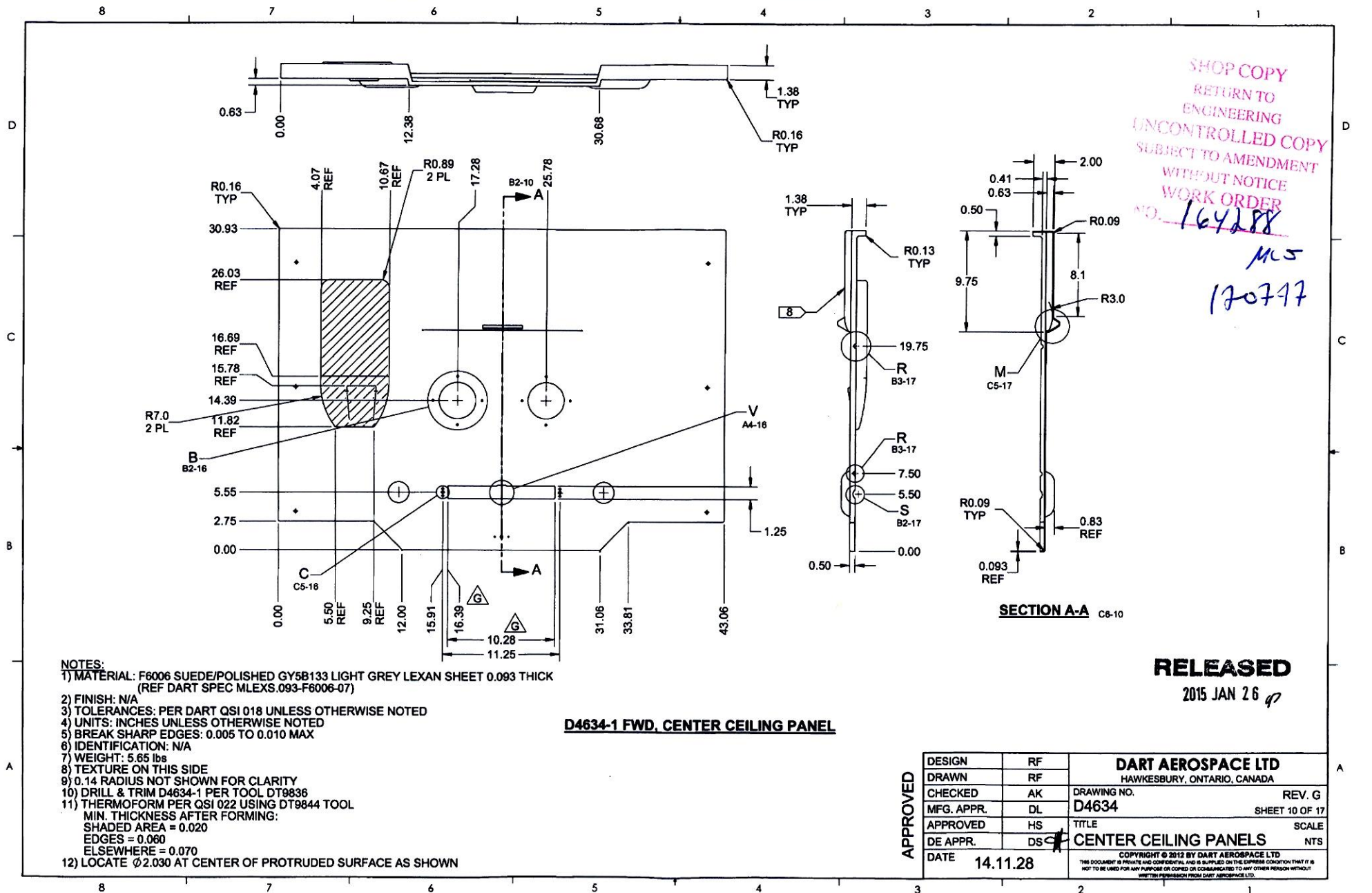


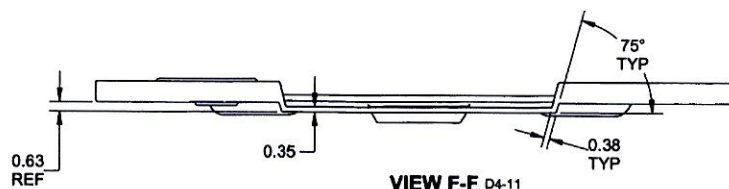
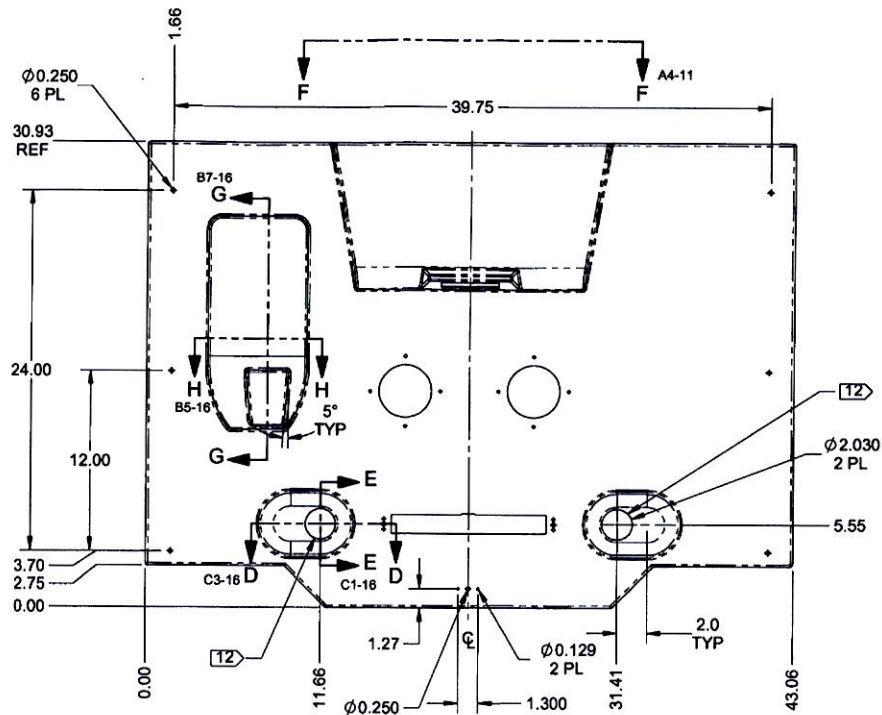
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																





VIEW F-F D4-11

D4634-1 FWD. CENTER CEILING PANEL
AUXILIARY VIEW

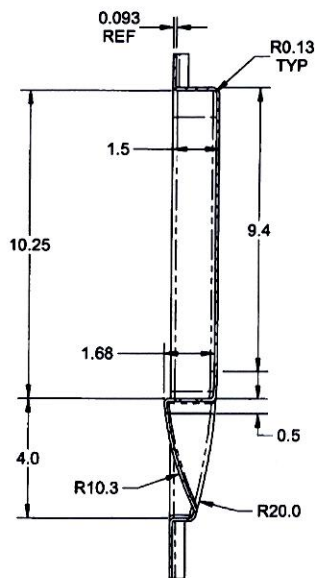
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2015 JAN 26

APPROVED

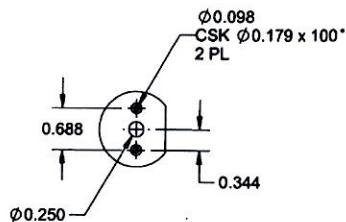
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DRAWN	RF		
CHECKED	AK	DRAWING NO.	REV. G
MFG. APPR.	DL	D4634	SHEET 11 OF 17
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CENTER CEILING PANELS	NTS
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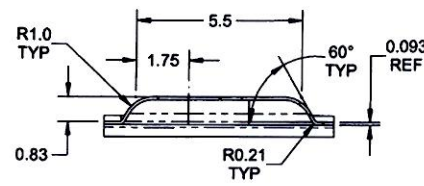
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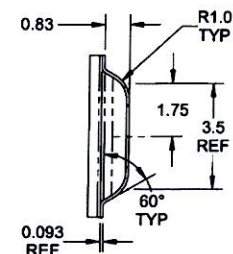
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SCALE 4X C5-11



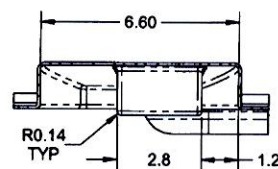
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SCALE 4X B7-10
B4-12
B4-14



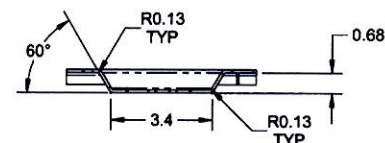
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C4-13
C4-16



SECTION E-E
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C4-13
C5-15

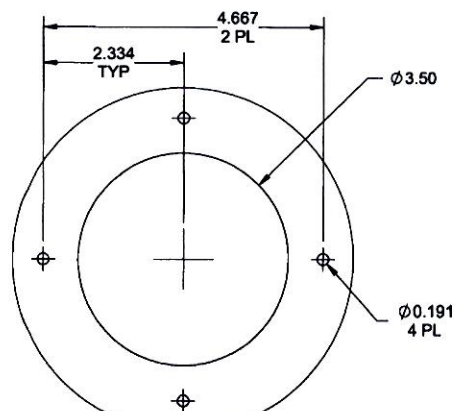


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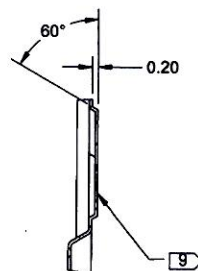


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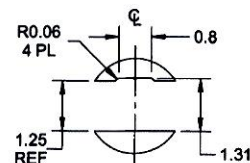
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DETAIL B
SCALE 4X
2 PL B7-10



DETAIL L
SCALE 4X
TYP B2-13
C2-13
B2-14
C2-14



DETAIL V
SCALE 2X
SIMILAR C4-10
B4-12
C4-14

RELEASED
2015 JAN 26

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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	DL	D4634	SHEET 16 OF 17
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DE APPR.	DS	CENTER CEILING PANELS	NTS
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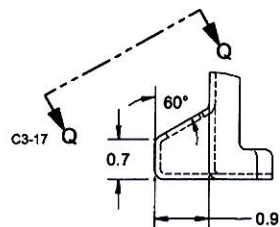
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C

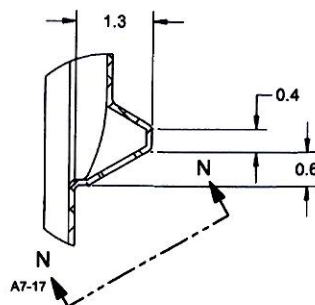
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A

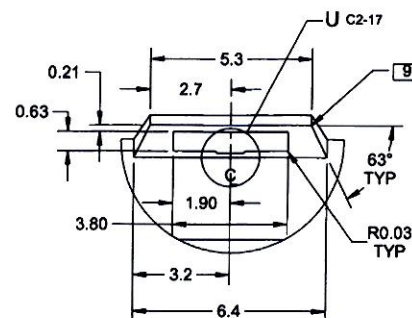
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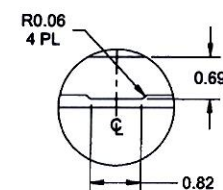
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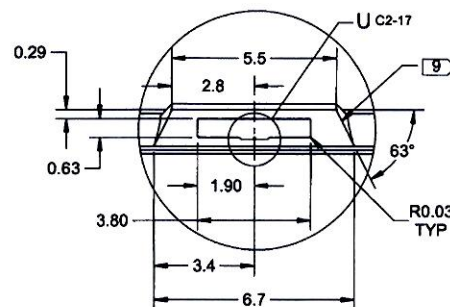
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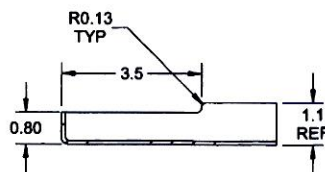
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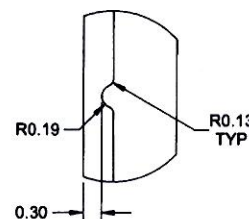
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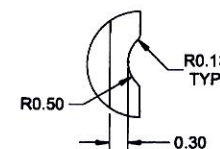
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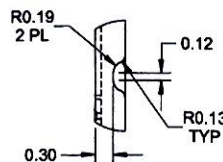
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SCALE 1.3X B6-14



DETAIL R
SCALE 4X B3-10
C3-10
B2-12



DETAIL S
SCALE 4X B3-10
C2-12



DETAIL T
SCALE 4X C2-14

RELEASED
2015 JAN 26

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	MFG. APPR.	DL	D4634	SHEET 17 OF 17
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO37108**

Purchase Order Date 7/19/2017

PO Print Date 7/19/2017

Page Number 5 of 9

Order From :

VC-PLT01

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

PLAS-TECH
115 APPLEWOOD CRESCENT
CONCORD, ONTARIO L4K 5C1

Contact Name

Vendor Phone 416-736-0004

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

					Line Total:	\$200.00
13	D4634-1P	Fwd, Center Ceiling Panel	7/31/2017 Yes 7/31/2017	4.00 Each	\$100.00	\$400.00
MANUFACTURE AS PER DWG D4634 REV. G B164288						
					Line Total:	\$400.00
14	D4634-3P	Middle, Center Ceiling Panel	7/31/2017 Yes 7/31/2017	3.00 Each	\$100.00	\$300.00
MANUFACTURE AS PER DWG D4634 REV. G B164289						
					Line Total:	\$300.00
15	D4634-5P	Aft, Center Ceiling Panel	7/31/2017 Yes 7/31/2017	4.00 Each	\$100.00	\$400.00
MANUFACTURE AS PER DWG D4634 REV. G B164290						

Note:

7/19/2017

Packing Slip



115 Applewood Crescent
Concord, ON, L4K 5C1
PLASTECHONLINE.COM
P- 416 736 0004
F- 416 736 0010

Shipment Number: 24077
Shipment Date: 08/25/2017
BOL Number:
Customer Key: C1887
Salesperson: MIKE AUBE
Page Number: 2 of 2

B DART AEROSPACE LTD.
I 1270 ABERDEEN STREET
L HAWKESBURY ON K6A 1K7
L CA
T Attn: ROBERT ABOUD
O Buyer Contact: ROBERT ABOUD

S DART AEROSPACE
H 1270 ABERDEEN STREET
I HAWKESBURY ON K6A 1K7
P CA
T Attn: ROBERT ABOUD
O

Item Number - Revision	Description	Quantity Shipped	UOM
D4634-1P - Rev.: G	FWD, CENTER CEILING PANEL HS Code: 3920.61.1000 - OTHER Country of Origin : CA	4	EA
D4634-3P - Rev.: G	MIDDLE, CENTER CEILING PANEL HS Code: 3920.61.1000 - OTHER Country of Origin : CA	3	EA
D4634-5P - Rev.: G	AFT, CENTER CEILING PANEL HS Code: 3920.61.1000 - OTHER Country of Origin : CA	4	EA
D4635-1 - Rev.: F	FWD CEILING PANEL, LH AS PER DWG D4635 REV. F HS Code: 3920.61.1000 - OTHER Country of Origin : CA	3	EA
D4635-2 - Rev.: F	FWD CEILING PANEL, RH AS PER DWG D4635 REV. F HS Code: 3920.61.1000 - OTHER Country of Origin : CA	3	EA
D4635-3 - Rev.: F	AFT CEILING PANEL, LH AS PER DWG D4635 REV. F HS Code: 3920.61.1000 - OTHER Country of Origin : CA	3	EA
D4635-4 - Rev.: F	AFT CEILING PANEL, RH AS PER DWG D4635 REV. F HS Code: 3920.61.1000 - OTHER Country of Origin : CA	3	EA

SPN 8-30

Number of Containers

Gross Weight

Shipped By